

Work Order ID 86498

86498

Page 1

Friday, June 29, 2012 3:40:40 PM

Item ID: D2221

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: 350 Basket Base

Stop ***NS2***

Start Date: 6/29/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 7/13/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: CME Date: 12-06-19 Tooling:

Run Start ***NR1***

QC: Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr Revision Nbr

D2221 Rev H

100 0.00

100

Large Fab

Large Fab

Memo 0.00

Large Fab

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221
2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221
3- tack weld mesh on basket as per dwg D2221
A/R ER316 S.S. Rod Batch: 121602

PLEASE NOTE

IF MAKING -041A OR -043A !
DRILL HOLES FOR GAS SPRING
IN D3825-041 AS PER
DSI 9473

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Memo 0.00

Quality Control

1x PL 12-07-19

1 12-07-19

DAS
18
12-07-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

125

Pressure Wash per QSI005 4.3

0.00

125

HandFinish

Memo

0.00

Hand Finishing

DAS
16
9-80
12/07/20

1 0 12-7-20

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Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

130

Powdercoat

Powder Coating

Memo

0.00

1- Plug holes prior to

1ST COAT:

START TIME: 9:00

OVEN TEMPERATURE: 400 OF

FINISH TIME: 9:30

***** 2nd coat if necessary*****

2ND COAT:

START TIME: 9:30

OVEN TEMPERATURE: 400 OF

FINISH TIME: 9:30

140

QC3- Inspect Part Finish

0.00

140

QC

Quality Control

Memo

0.00

W121841

IX 12/07/20

1 12-7-20

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Date:

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QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Identify as per dwg & Stock Location: D350 6007-043A.

86498

150

Packaging

Memo

0.00

Packaging

1 12-7-20

160

QC21 - Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

MCJ 12/07/20

MCJ
12/07/20

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Picklist Print

Friday, June 29, 2012 3:40:39 PM

Page 1

Work Order ID: 86498
Parent Item: D2221
Parent Item Name: 350 Basket Base

Start Date: 6/29/2012

Required Date: 7/13/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:J 05.09.02 Added D3442-1 KJ/JLM
IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC
IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
IPP Rev:M 08-12-02 revH as per dwg DD verified by:EC IPP Rev:N 10.06.29 added pressure wash DD ver:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D2221-1 Rib		Manufactured	No			100	Each	8.0000	1	1			
						<u>Loc Qty</u>	<u>Loc Code</u>						
						WA	8						
						83907	8						
J D2221-5 Rib		Manufactured	No			100	Each	21.0000	2	2			
						<u>Loc Qty</u>	<u>Loc Code</u>						
						WA	19						
						83914	4						
						84793	15						
						WA006	2						
						67117	2						
J D2221-7 Rib		Manufactured	No			100	Each	7.0000	1	1			
						<u>Loc Qty</u>	<u>Loc Code</u>						
						WA	5						
						84762	5						
						WA006	2						
						81041	2						

382950 → 1x SY 12.07.17

SY 12.07.17

SY 12.07.17

1x

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Start Date: 6/29/2012

Required Date: 7/13/2012

Start Qty: 1.00

Required Qty: 1.00

✓ D2232-3 Basket Hinge	Manufactured	No	100	Each	15.0000	2	2	SY 12.07.17
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA	13				
			82304	3				
			85698	10		2x		
			WA005	2				
			75581	2				
✓ D2235-1 Basket Rib	Manufactured	No	100	Each	20.0000	2	2	B86356 → 1x SY 12.07.17
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA	16				
			78636	5				
			81910	1				
			85602	4				
			86051	6		1x		
			WA005	4				
			66895	4				
✓ D2581 Mounting Bracket	Manufactured	No	100	Each	67.0000	2	2	B86658 → 2x SY 12.07.17
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA	45				
			82506	2				
			83230	3				
			85436	16				
			85452	24				
			WA005	22				
			70766	2				
			81253	1				
			82897	19				

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Shop Packet Print

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Page 3

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Parent Item Name: 350 Basket Base

Start Date: 6/29/2012

Required Date: 7/13/2012

Start Qty: 1.00

Required Qty: 1.00

✓ D3442-1 Shim	Manufactured	No	100	Each	17.0000	2	2	SL 12.07.17
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA	17				
			80788	17				
✗ D3825-041 Rib Assembly (Basket End)	Manufactured	No	100	Each	10.0000	2	2	SL 12.07.17
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA	10				
			83912	4				
			83913	6				
✓ D3826-041 Rib / Gusset Assembly	Manufactured	No	100	Each	6.0000	2	2	SL 12.07.17
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA	6				
			81571	6				
✓ D3827-041 Rib Assembly (Inboard)	Manufactured	No	100	Each	11.0000	1	1	SL 12.07.19
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA	5				
			81038	5				
			WA006	6				
			72729	1				
			84792	5				
✓ D3832-1 Mesh (Base)	Manufactured	No	100	Each	3.0000	1	1	SL 12.07.18
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA	3				
			85175	3				

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Parent Item Name: 350 Basket Base

Start Date: 6/29/2012

Required Date: 7/13/2012

Start Qty: 1.00

Required Qty: 1.00

✓ D3833-1 Manufactured No 100 Each 16.0000
Mesh (Base End Face)

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	4	
77521	4	
WA035	12	
81259	1	
85697	11	

2
~~B86362~~ → 2x
B86314 → 2x
10-07-17

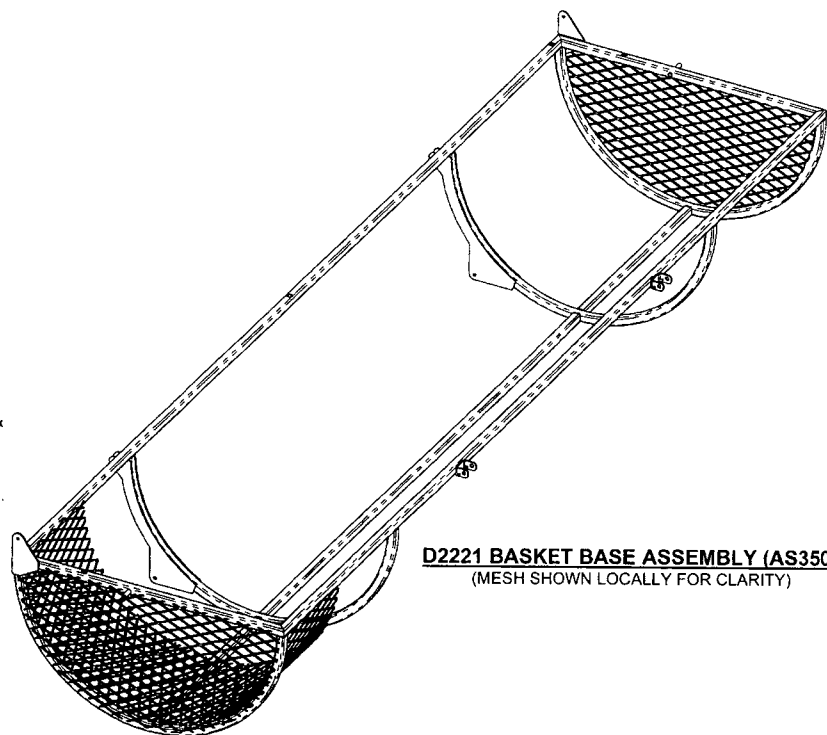
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D2221 BASKET BASE ASSEMBLY (AS350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: 42.00 lbs APPROX
- 9) MASK ALL HOLES PRIOR TO POWDER COATING

ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/5-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL. TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JS		
CHECKED	JS	DRAWING NO.	REV. H
MFG. APPR.	JS	D2221	SHEET 1 OF 5
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

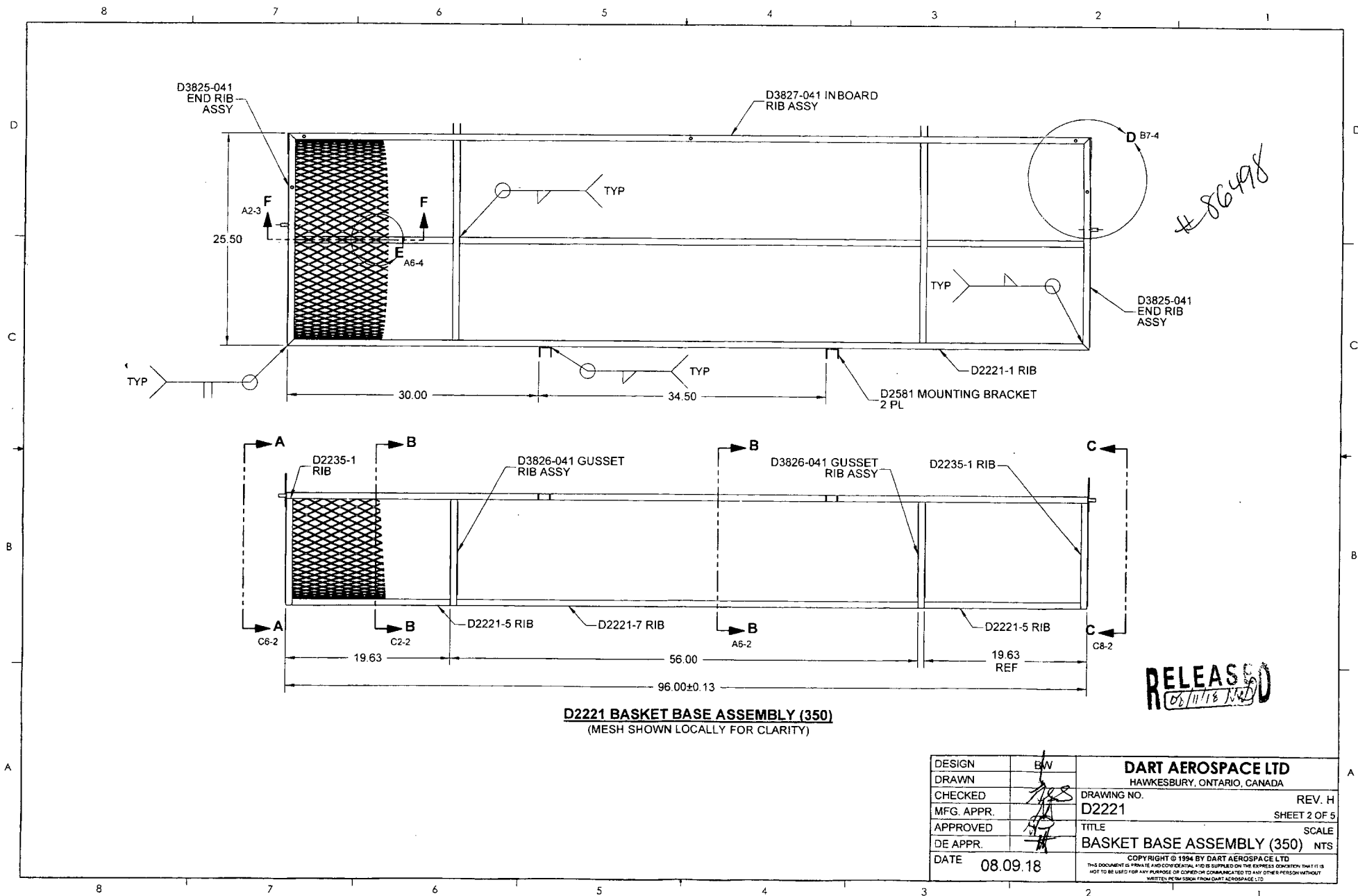
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DRAWN		DRAWING NO.	REV. H
CHECKED		D2221	SHEET 2 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		BASKET BASE ASSEMBLY (350)	NTS
DE APPR.		COPYRIGHT © 1994 BY DART AEROSPACE LTD	
DATE	08.09.18	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COVER OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

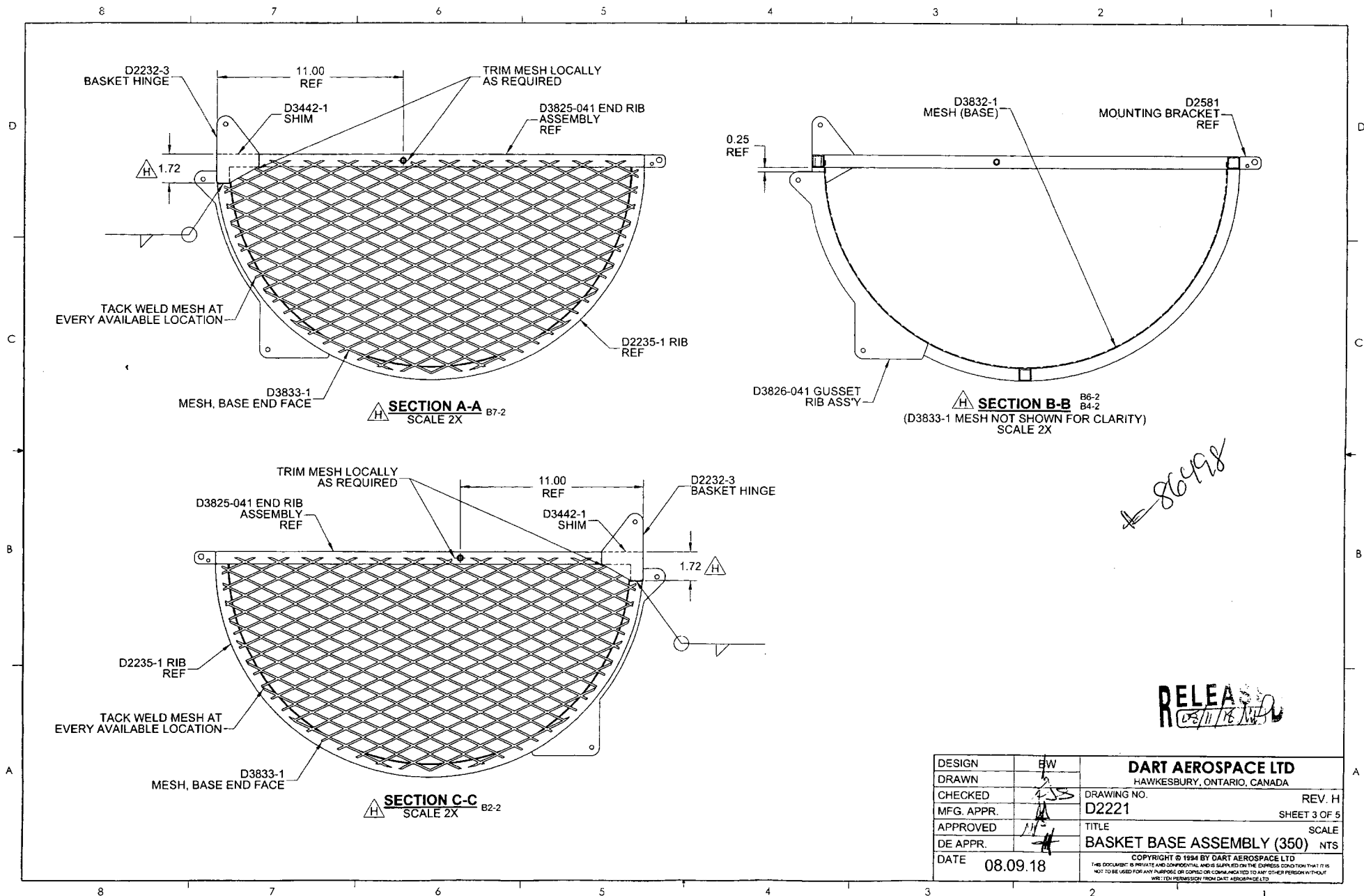
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DRAWN	255	HAWKESBURY, ONTARIO, CANADA	
CHECKED	11	DRAWING NO. D2221	REV. H
MFG. APPR.			SHEET 3 OF 5
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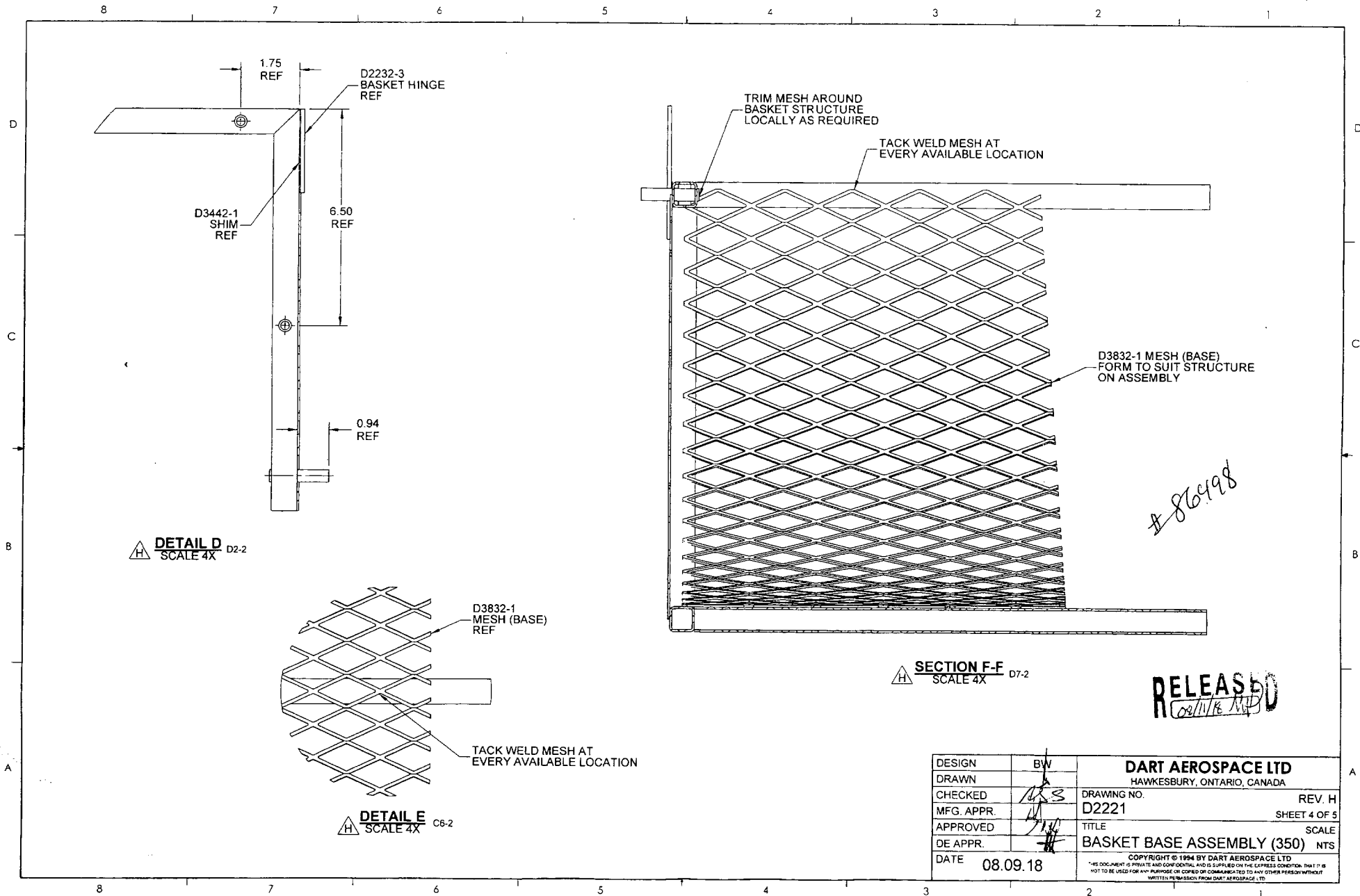
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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. D2221	REV. H
MFG. APPR.	<i>[Signature]</i>	SHEET 4 OF 5	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET BASE ASSEMBLY (350) NTS	
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD <small>*THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

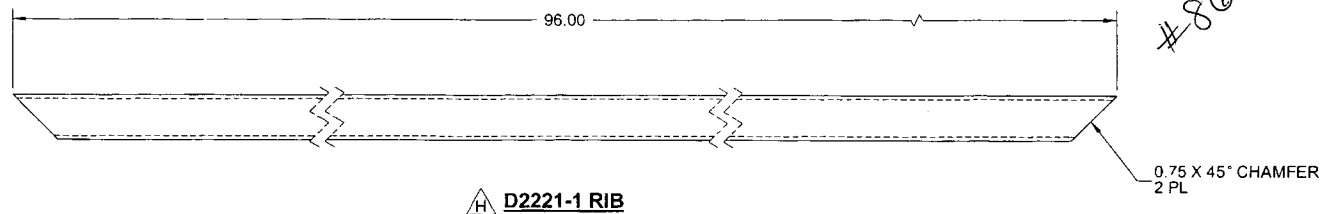
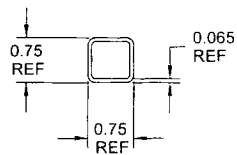
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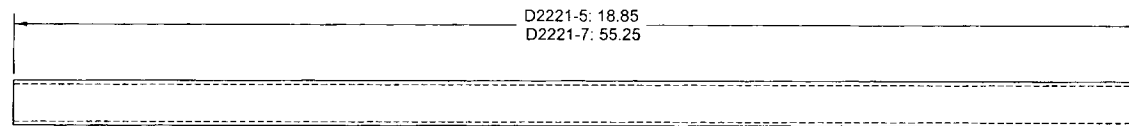
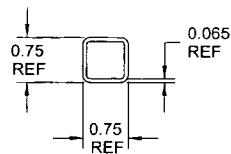
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D2221-1 RIB



D2221-5/-7 RIB

RELEASED
08/11/18

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. H
MFG. APPR.	MS	D2221	SHEET 5 OF 5
APPROVED	MS	TITLE	SCALE
DE APPR.	MS	BASKET BASE ASSEMBLY (350) NTS	
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries